



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5669-041
Job Sheet 189637



Part No: D5669-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/29/19

Job Tracking No:

Due Date: 2/8/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: TBD DWG D5669 REV.A IPP REV:A 18.07.23 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
90	Start up Operation	1 Ea	2/8/19	2/8/19	0.00	0.00	Start Up Large Fab-5	CL
100	Large Fab	1 pcs	2/8/19	2/8/19	0.00	6.67	Large Fab 1	CL
110	QC	1 pcs	2/8/19	2/8/19	0.00	0.00	QC9	CL
120	QC	1 pcs	2/8/19	2/8/19	0.00	0.00	QC5	CL
130	Powdercoat - 4 Black Sand - B4B	1 pcs	2/8/19	2/8/19	0.00	0.40	Powdercoat - 1 - B4B	CL
							Powdercoat - 2 - B4B	CL
							Powdercoat - 3 - B4B	CL
							Powdercoat - 4 - B4B	CL
135	QC	1 pcs	2/8/19	2/8/19	0.00	0.00	QC3	CL
140	HandFinish	1 pcs	2/8/19	2/8/19	0.00	0.80	HandFinish4	CL
150	QC	1 pcs	2/8/19	2/8/19	0.00	0.00	QC5	CL
160	Packaging	1 pcs	2/8/19	2/8/19	0.00	0.00	Packaging3-2	CL
170	QC21-SA	1 Ea	2/8/19	2/8/19	0.00	0.00	QC21	CL

Part Op 100 - 1- Assemble ribs , weld as per dwg D5669 using DT9607A 2- Weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- Cut lid mesh as per dwg 4- Tack weld mesh on basket as per dwg
D5669 ***Cut out mesh where label plate goes in center off basket lid as per dwg. Make sure to place mesh correctly on
lid, check with label plate before tacking mesh*** ***CUT OUT MESH ON TOP OF D2581 1.5" HIGH*** ***DOUBLE
CHECK WITH A HANDLE*** 5- *****SCRIBE ID AS PER DWG NOTE 6 ON SHEET 1****
120 - *****SCRIBE ID AS PER DWG NOTE 6 ON SHEET 1****
130 - *** Mask holes as per note 9, sides of hinge and note 11 prior to powdercoat*** START TIME: 10:10 OVEN
TEMPERATURE: 375° FINISH TIME: 10:25 M138997
140 - 1- Assemble as per dwg 2- Mask data plate and apply wing walk on outside surface of mesh as per dwg and QSI
Wing Walk batch: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	90-Start up Operation	5143339
D3914-1	Rib	2 pcs (2 ea)	90-Start up Operation	5145084
D4016-3	Hinge Half, Lid	3 pcs (3 ea)	90-Start up Operation	5110937
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea)	90-Start up Operation	5145630
D5670-1	Rib	4 pcs (4 ea)	90-Start up Operation	2X5146832 / 2X5144656
D5670-3	Rib	9 pcs (9 ea)	90-Start up Operation	5149313
D5672-1	Data Plate	1 pcs (1 ea)	90-Start up Operation	5133197
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	90-Start up Operation	5125258
AN3-14A	Bolt	4 Ea (4 ea)	140-HandFinish	5143225
AN3-16A	Bolt	2 Ea (2 ea)	140-HandFinish	5045859
AN5-17A	Bolt	2 Ea (2 ea)	140-HandFinish	5143682
D2530	Handle Weldment	1 pcs (1 ea)	140-HandFinish	*5152273
D2535	Spring	2 pcs (2 ea)	140-HandFinish	5147273
D2537-PO	Bushing	2 pcs (2 ea)	140-HandFinish	5123161
D3953-17	Gas Spring Spacer	2 pcs (2 ea)	140-HandFinish	5135367
D3953-19	Gas Spring Bracket	2 pcs (2 ea)	140-HandFinish	5143335
MS21042L3	Nut	6 Ea (6 ea)	140-HandFinish	5094592
MS21042L5	Nut	2 Ea (2 ea)	140-HandFinish	5142139
NAS1149F0332P	Washer	8 Ea (8 ea)	140-HandFinish	5134693-1
NAS1149F0563P	Washer	2 Ea (2 ea)	140-HandFinish	5098031-3

M. U. 008072.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	91	0
	D3914-1	2	8	0
	D4016-3	3	159	0
	D4035-043	2	14	0
	D5670-1	4	6	0
	D5670-3	9	9	0
	D5672-1	1	7	0
	M304EX0.75-16F	32	2,331	0
140-HandFinish	AN3-14A	4	267	0
	AN3-16A	2	35	0
	AN5-17A	2	97	0
	D2530	1	5	0
	D2535	2	55	0
	D2537	2	0	0
	D3953-17	2	15	0
	D3953-19	2	44	0
	MS21042L3	6	1,976	0
	MS21042L5	2	302	0
	NAS1149F0332P	8	1,957	0
	NAS1149F0563P	2	504	0

Part Specifications

Specifications could not be found.

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S151461



Part: D5669-041

Job No: 189637

Serial No/Batch: S151461

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 02/06/19